

Work Order ID 71180

Page 1

Thursday, June 23, 2011 11:53:00 AM

Item ID:	D2258-200	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Placard 200lb					
Start Date:	6/23/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	6/30/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CZ</u>	Date:	<u>11/06/23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2258	E								

100		0.00							
	PURCHASING								<u>CZ 11/06/23 12</u>
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>14358</u>								
	Make D2258-200 read 200lb / 91kg as per Dwg D2258								
	Material: Red letters (1.00" min height) with adhesive back Manufacture from								
	3M 7mil masking film #8522CP or Avery IPM #2031								
	Material release note is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure material release note is attached								<u>Rec'd 6/29</u> <u>(12)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71180

Thursday, June 23, 2011 11:53:00 AM



Page 2

Item ID: D2258-200

Accept



Setup Start



Revision ID:

Stop



Item Name: Placard 200lb

Start Date: 6/23/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Suloe/29

4/2

Quality Control

130

Identify as per dwg & Stock Location: ST 505

0.00



Packaging

Memo

0.00

Packaging

L JB (12) 1/06/29

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/6/29 J
11-06-29
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 11:52:57 AM

Page 1

Work Order ID: 71180



Parent Item: D2258-200



Parent Item Name: Placard 200lb



Start Date: 6/23/2011

Required Date: 6/30/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: B04.04.15 Reformat; Clarify Step 2 KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2258-200P  Weight Placard 200lb		Purchased	No				Each	0.0000		12		<i>6/29/25</i>	<i>(12)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

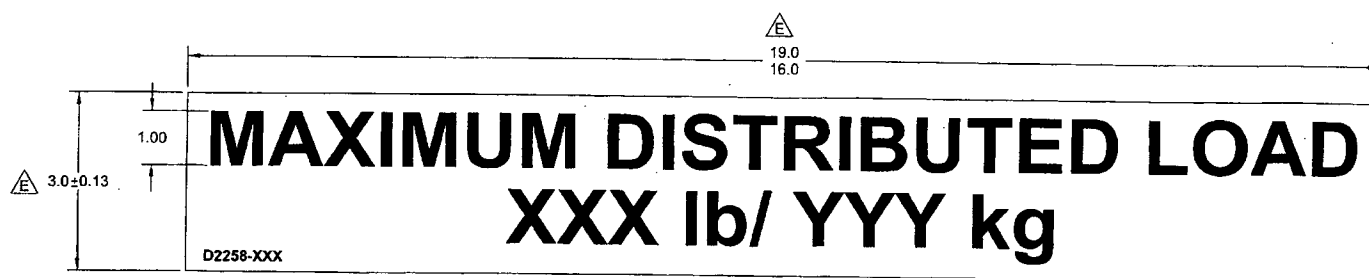
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D2258-XXX PLACARD
(XXX = ALLOWABLE WEIGHT IN POUNDS)

PART NUMBER	LOAD
D2258-132	132 lb/ 60 kg
D2258-146	146 lb/ 66 kg
D2258-160	160 lb/ 73 kg
D2258-170	170 lb/ 77 kg
D2258-176	176 lb/ 80 kg
D2258-200	200 lb/ 91 kg
D2258-220	220 lb/ 100 kg
D2258-300	300 lb/ 136 kg

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71180
CX11/06/23

RELEASED
2010-01-25
MP

NOTES:
1) MATERIAL: RED LETTERS, 1 HIGH, ADHESIVE BACK
MANUFACTURED FROM 3M, 7 MIL MASKING FILM #8522CP OR
AVERY IPM #2031
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A
8) PART NUMBER = D2258-MAX DISTRIBUTED WEIGHT IN POUNDS (lbs) OF THE BASKET.
EXAMPLE: D2258-132 IS A BASKET WITH MAX DISTRIBUTED WEIGHT OF 132 POUNDS (lbs).

E	ADD P/N D2258-146 (ZN B5-1) UPDATE TOLERANCE AS PURCHASED (ZN D4-1, D8-1)	CP	10.01.15
D	ADD P/N D2258-176	<i>CP</i>	09.06.03
C	REDRAWN. SEE PAR 08-026	AJS	08.10.29
B	ADDED NOTE	BW	95.11.29
A	NEW ISSUE	BW	94.02.28
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>CP</i>	DRAWING NO.	REV. E
CHECKED	<i>CP</i>	D2258	SHEET 1 OF 1
MFG. APPR.	<i>CP</i>	TITLE	SCALE
APPROVED	<i>CP</i>	UTILITY BASKET PLACARD	NTS
DE APPR.	<i>CP</i>	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.01.15		

8 7 6 5 4 3 2 1

210 Main Street W
Hawkesbury, Ontario K6A 2H6

Invoice No.: 15988
Date: 06/27/2011
Ship Date:
Page: 1
Re: Order No. 11109

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Dart Aerospace Ltd
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		12	D2258-200P set up	H	4.1667	50.00
		10	D3428-1P set up	H	5.0000	50.00
		6	D3997-1P set up	H	8.3333	50.00
		10	D3997-5P set up	H	5.0000	50.00
		1	printing	H	50.0000	50.00
			H - HST 13%			
			HST			32.50
			PST Exempt: #6122-5207			
			8/16/29			
Studio de Lettrage HST: #869034678RP001						
Shipped By:					Total Amount	
Comment: PO 14358						282.50
Sold By:						



PRODUCT DATA BULLETIN

Product Data Bulletin: A5-O

Avery Graphics™ A5 Opaque
5-year **INTERMEDIATE** calendered vinyl film
Dated: 10/3/02

Description:

Avery Graphics™ A5 Opaque intermediate films are flexible, high-gloss calendered vinyls designed for use on computer sign cutting equipment. This construction provides excellent cutting, weeding and transferring characteristics for signage applications.

Application information can be found in the Avery Graphics Application Guide.

For surface preparation, converting and printing, and application and removal instructions, please refer to the Avery Graphics Instructional Bulletin.

Construction:

- Face Film: 3.2 mils opaque medium gloss intermediate calendered vinyl film
- Adhesive: 1.0 mil clear acrylic permanent solvent pressure-sensitive adhesive
- Liner: 78# bleached white kraft

Physical Properties:

The following information on physical and chemical characteristics is based upon tests believed to be reliable. The values are intended only as a source of information. They are given without guarantee and do not constitute a warranty. The purchaser should independently determine, prior to use, the suitability of this material for his/her specific purpose. (Data represents averages and is not intended for use as a specification).

- Outdoor durability: 5 years when properly processed and applied (vertical exposure, unprinted film)**
- Application surface contours: Flat and simple curves
- Minimum surface and air application temperature: +50° F (10° C)
- Service Temperature Range: -40° F to +180° F (-40° C to 82° C) (Reasonable range of temperatures which would be expected under normal environmental time and temperature conditions)
- Typical Chemical Resistance: Resistant to most mild acids, alkalis and salt solutions. See instructional bulletin for recommendations on cleaning.
- Shelf Life: One year when stored at the following temperatures and humidity conditions: 68°-77° F (20° - 25° C) and 50±5% R. H.
- Typical Adhesion Values: **180° Peels**

Substrate	24 hrs	1 week
Stainless Steel	4.4 lbs/in	5.1 lbs/in
Glass	4.7 lbs/in	5.3 lbs/in

NOTE: Tested per ASTM D 1000. Always pre-test your specific substrate prior to actual application.

- Reflectivity: NA
- Typical Gloss*: 70 at 60°

- Tensile at Yield: 9.0 lbs/in to 15.0 lbs/in width
- Elongation: 100% minimum
- Dimensional Stability: Less than 0.03 in. (0.762mm). Shrinkage is determined by measuring shrinkage of unprinted film applied to 36 in.² (91 cm²) aluminum test panel after 72 hrs. aging at 73° F (23° C) 50±5% R.H. followed by 48 hrs. at 150° F (65° C).

Typical Converting Methods:

CUTTING

Computer Sign Cutting: yes
Angle of Blade: 30° or 45°
Minimum letter Height: 0.5 inch

PRINTING

Thermal Transfer Printing: yes
Ink Jet Printing: no
E-Stat printing: no
Screen Printing: no

Exceptions:

Durability Exceptions: Colors with reduced durabilities are as follows: A5077-O Silver and A5247-O Gold are 3-year durable and A5003-O Clear is 4-year durable.

Gloss Exceptions: A5077-O Silver, A5247-O Gold and A5508-O Vibrant Blue have a typical gloss of 50 at 60°.

Pigmented Adhesive Exceptions: none

** Some color fade may occur in severe environmental areas such as, Florida, Arizona, Nevada, New Mexico, Utah, Southwest Texas and Southern California. Durability statement does not apply outside of the contiguous 48 states as testing has not been done in those regions.

WARRANTY: All statements, technical information and recommendations about Avery Dennison products are based upon tests believed to be reliable but do not constitute a guarantee or warranty. All Avery Dennison products are sold with the understanding that Purchaser has independently determined the suitability of such products for its purposes. Avery Dennison products are warranted to be free from defects in material and workmanship for either one year (or the period stated on the specific product information literature in effect at time of delivery, if longer) from date of shipment if said product is properly stored and applied. It is expressly agreed and understood that Avery Dennison's sole obligation and Purchaser's exclusive remedy under this warranty, under any other warranty, express or implied, or otherwise, shall be limited to repair or replacement of defective product without charge at Avery Dennison's plant or at the location of product (at Avery Dennison's election), or in the event replacement or repairs is not commercially practical, to Avery Dennison's issuing Purchaser a credit reasonable in light of the defect in the product.

Avery Dennison's liability for defective products shall not exceed the purchase price paid therefore by Purchaser and in no event shall Avery Dennison be responsible for any incidental or consequential damages whether foreseeable or not, caused by defects in such product, whether such damage occurs or is discovered before or after replacement or credit, and whether or not such damage is caused by Avery Dennison's negligence.

NO EXPRESS WARRANTIES AND NO IMPLIED WARRANTIES, WHETHER OF MERCHANTABILITY OR FITNESS FOR ANY PARTICULAR USE, OR OTHERWISE (EXCEPT AS TO TITLE), OTHER THAN THOSE EXPRESSLY SET FORTH ABOVE WHICH ARE MADE EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, SHALL APPLY TO PRODUCTS SOLD BY AVERY DENNISON. AVERY DENNISON SPECIFICALLY DISCLAIMS AND EXCLUDES ALL OTHER SUCH WARRANTIES. NO WAIVER, ALTERATION, ADDITION OR MODIFICATION OF THE FOREGOING CONDITIONS SHALL BE VALID UNLESS MADE IN WRITING AND MANUALLY SIGNED BY AN OFFICER OF AVERY DENNISON.